

IN THE CLAIMS:

Listing of claims:

1-19 (canceled)

20. (previously presented) A method as in claim 24, wherein the first layer comprises an epitaxial growth layer.

21. (currently amended) A method as in claim 24, ~~further comprising removing the polishing stopper layer after planarizing the dielectric layer~~ wherein the thermally treating the dielectric layer is carried out at a temperature of at least 1100°C.

22. (previously presented) A method as in claim 24, further comprising oxidizing at least a portion of the first layer in the at least one trench prior to forming the dielectric layer in and above the trench.

23. (previously presented) A method as in claim 22, further comprising, after the implanting impurities to form a well in the first layer, removing the entire sacrificial oxide layer.

24. (currently amended) A method for manufacturing a semiconductor device including a trench isolation region, the method comprising:

- providing a semiconductor substrate having a first layer thereon ;
- forming a pad layer on the first layer;
- forming a polishing stopper layer on the pad layer;
- forming at least one trench by etching the first layer while using at least the polishing stopper layer as a mask;
- forming a dielectric layer in and above the trench;
- planarizing the dielectric layer using the polishing stopper layer as a stopper;
- removing the polishing stopper layer after the planarizing the dielectric layer;

removing the pad layer and exposing the first layer, after the removing the polishing stopper layer;

forming a sacrificial oxide layer in direct contact with the first layer, after the removing the pad layer, wherein the sacrificial oxide layer consists of an oxide layer formed by thermally oxidizing the first layer;

thermally treating the dielectric layer at a temperature of at least 1050°C after the forming the sacrificial oxide layer; and

after the thermally treating the dielectric layer at a temperature of at least 1050°C, implanting impurities to form a well in the first layer.

25. (previously presented) A method as in claim 24, wherein the thermally treating the dielectric layer is carried out in an atmosphere comprising 0.1 volume % to 10 volume % oxygen.

26. (previously presented) A method as in claim 24, wherein the dielectric layer is formed using high density plasma chemical vapor deposition.

27-39. (canceled)

40. (currently amended) A method for manufacturing a semiconductor device having a trench isolation region, the method comprising:

forming a polishing stopper layer on a an epitaxially grown semiconductor layer;
forming an opening in the polishing stopper layer and a trench in the semiconductor layer;
forming a dielectric layer in the trench, in the opening in the stopper layer, and on the stopper layer;

planarizing the dielectric layer using the polishing stopper layer as a stop;
removing the polishing stopper layer after the planarizing the dielectric layer;
conducting a thermal treatment of the dielectric layer after removing the polishing stopper layer, wherein the thermal treatment is conducted at a temperature of at least ~~1050~~1100°C; and

after the thermal treatment of the dielectric layer, performing a first implanting operation into the semiconductor layer including implanting impurity ions into the semiconductor layer.

41. (previously presented) A method for manufacturing a semiconductor device having a trench isolation region according to claim 40, further comprising forming a pad layer on the semiconductor layer prior to forming the polishing stopper layer, wherein the pad layer is formed between and in direct contact with the semiconductor layer and the polishing stopper layer.

42. (previously presented) A method according to claim 41, wherein the opening in the polishing stopper layer also extends through the pad layer.

43. (previously presented) A method according to claim 42, further comprising isotropically etching the pad layer and upper portions of the dielectric layer after the removing the polishing stopper layer and prior to the conducting the thermal treatment.

44-46. (canceled)

47. (previously presented) A method for manufacturing a semiconductor device having a trench isolation region according to claim 40, wherein the dielectric layer is formed with a film density of at least 2.1 g/cm^3 .

48. (canceled)

49. (currently amended) A method for manufacturing a semiconductor device having a trench isolation region according to claim 40, wherein the temperature of the thermal treatment is in the range of ~~1050~~1100°C to 1250°C.

50. (previously presented) A method for manufacturing a semiconductor device having a trench isolation region according to claim 40, wherein the dielectric layer is formed by a high density plasma CVD method.

51. (previously presented) A method for manufacturing a semiconductor device having a trench isolation region according to claim 40, wherein the trench includes sidewall surfaces and a bottom surface, the method further comprising of thermally oxidizing the sidewall surfaces and the bottom surface of the trench to form a thermal oxide layer thereon, wherein the dielectric layer is formed in direct contact with the thermal oxide layer.

52. (previously presented) A method for manufacturing a semiconductor device having a trench isolation region according to claim 51, wherein the thermally oxidizing the sidewall surfaces and the bottom surface of the trench is carried out at a temperature in the range of at 700°C to 1150°C.

53. (previously presented) A method for manufacturing a semiconductor device having a trench isolation region according to claim 51, wherein the thermally oxidizing the sidewall surfaces and the bottom surface of the trench is carried out at a temperature in the range of 950 to 1150°C.

54. (previously presented) A method for manufacturing a semiconductor device having a trench isolation region according to claim 51, wherein the thermally oxidizing the sidewall surfaces and the bottom surface yields an oxidation layer having a thickness in the range of 10 nm to 100 nm.

55. (canceled)

56. (previously presented) A method for manufacturing a semiconductor device having a trench isolation region according to claim 40, wherein the trench is formed with a trench width of no greater than 0.35 μm .

57-59. (canceled)

60. (currently amended) A method for manufacturing a semiconductor device including a trench isolation region, the method comprising:

providing a an epitaxially grown semiconductor layer;

forming a pad oxide layer on the semiconductor layer;

forming a polishing stopper layer in direct contact with the pad oxide layer, wherein the pad oxide layer is positioned between the semiconductor layer and the polishing stopper layer;

forming a patterned resist layer on the polishing stopper layer, the patterned resist layer including an open region exposing part of the polishing stopper layer over a trench formation region;

using the patterned resist layer as a mask, etching the polishing stopper layer and the pad oxide layer so that a portion of the semiconductor layer is exposed;

after the etching, removing the patterned resist layer;

after the removing the patterned resist layer, etching the exposed portion of the semiconductor layer to form at least one trench therein, using the polishing stopper layer as a mask;

forming a dielectric layer in and above the at least one trench;

planarizing the dielectric layer using the polishing stopper layer as a stopper;

after the planarizing the dielectric layer, removing the polishing stopper layer and the pad oxide layer so that an upper surface of the semiconductor layer is exposed;

heating the dielectric layer to a temperature of at least ~~4050~~1100°C after the removing the polishing stopper layer and the pad oxide layer; and

after the heating the dielectric layer to a temperature of at least ~~4050~~1100°C, implanting impurity ions into the semiconductor layer to form a well in the semiconductor substrate.

61. (previously presented) A method according to claim 60, further comprising, after forming the at least one trench and prior to forming the dielectric layer, forming a thermal oxide layer on the semiconductor substrate in the at least one trench.

62. (canceled)

63. (currently amended) A method for manufacturing a semiconductor device including a trench isolation region, the method comprising:

- providing a semiconductor substrate having an epitaxial layer thereon;
- forming a pad layer on the epitaxial layer;
- forming a polishing stopper layer on the pad layer;
- forming at least one trench by etching the epitaxial layer while using at least the polishing stopper layer as a mask;
- forming a dielectric layer in and above the at least one trench;
- planarizing the dielectric layer using the polishing stopper layer as a stopper;
- etching the polishing stopper layer after planarizing the dielectric layer;
- etching the pad layer and exposing the epitaxial layer, after the etching the polishing stopper layer;
- forming a sacrificial oxide layer on the exposed epitaxial layer by thermally oxidizing the exposed epitaxial layer, after the removing the pad layer;
- wherein the sacrificial oxide layer is not formed on the dielectric layer;
- thermally treating the dielectric layer at a temperature of at least ~~4050~~1100°C after the forming the sacrificial oxide layer;
- after the thermally treating the dielectric layer at a temperature of at least ~~4050~~1100°C, implanting impurity ions in the epitaxial layer; and
- after the implanting impurity ions, removing the entire sacrificial oxide layer.

64. (previously presented) A method according to claim 63, further comprising forming a thermal oxide layer in the at least one trench prior to the forming a dielectric layer in and above the at least one trench.

65. (previously presented) A method according to claim 63, wherein the dielectric layer is formed with a film density of at least 2.1 g/cm^3 .

66. (previously presented) A method according to claim 65, wherein the dielectric layer is formed by a high density plasma CVD method.

67. (previously presented) A method according to claim 63, wherein the epitaxial growth layer has a thickness of at least $2 \text{ }\mu\text{m}$.

68. (new) A method for manufacturing a semiconductor device including a trench isolation region, the method comprising:

- providing a semiconductor substrate including an epitaxial growth layer;
- forming a pad layer on the epitaxial growth layer;
- forming a polishing stopper layer on the pad layer;
- forming at least one trench by etching the epitaxial growth layer while using at least the polishing stopper layer as a mask;
- forming dielectric layer in the trench and overfilling the trench with the dielectric layer;
- planarizing the dielectric layer using the polishing stopper layer as a stopper;
- etching the polishing stopper layer after the planarizing the dielectric layer;
- etching the pad layer and exposing the epitaxial growth layer, after the etching the polishing stopper layer, wherein an upper surface of the dielectric layer is positioned at a height above that of the exposed epitaxial growth layer;
- forming a sacrificial oxide layer on the exposed epitaxial layer by thermally oxidizing the exposed epitaxial growth layer, after the removing the pad layer;

thermally treating the dielectric layer at a temperature of at least 1100°C after the forming the sacrificial oxide layer;

after the thermally treating the dielectric layer at a temperature of at least 1100°C, implanting impurity ions in the epitaxial layer; and

after the implanting impurity ions, removing the entire sacrificial oxide layer.

69. (new) A method as in claim 68, wherein the thermally treating the dielectric layer is carried out at a temperature in the range of 1100-1250°C.